

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023218**Date Inspected:** 30-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 1

This QA inspector observed ZPMC in process of fit-up/ tack welding on Bike Path Handrail post to base plate. ZPMC QC inspector Zhang Ya Xu was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhu Tian Shu as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- Bike Path Handrail Sub-assembly

WPS-B-P-2112

Welder- 054456

2F/SMAW (Post to Base Plate)

Bay 5

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of heat straightening traveler rail. ZPMC CWI Zhu Tian Shu was present at this time of this observation and informed this QA inspector of the work that is in process. This QA inspector verified this information for the following location;

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Heat Straightening
HSR1 (B) 10291
3025TR1-001-001~011

Bay 7

This QA inspector observed ZPMC in process of SAW welding on cantilever box beam assembly. ZPMC QC inspector Liu Chuan Gang was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder operator and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BK3003-001-003, 004
WPS-B-T-2221-TC-U4a-S-2
Welder- 040831
1G/SAW/CJP

Bay 9

This QA inspector observed ZPMC in process of heat straightening traveler rail assemblies. ZPMC CWI Chen Shi Gang was present at this time of this observation and informed this QA inspector of the work that is in process. This QA inspector verified this information for the following location;

Heat Straightening
HSR1 (B) 10251
3012TR5-001

Heat Straightening
HSR1 (B) 10281
3012TR6-001

Heat Straightening
HSR1 (B) 10275
3012TR4-001

Heat Straightening
HSR1 (B) 10276
3012TR1-001

Heat Straightening
HSR1 (B) 10282
3024TR1-001

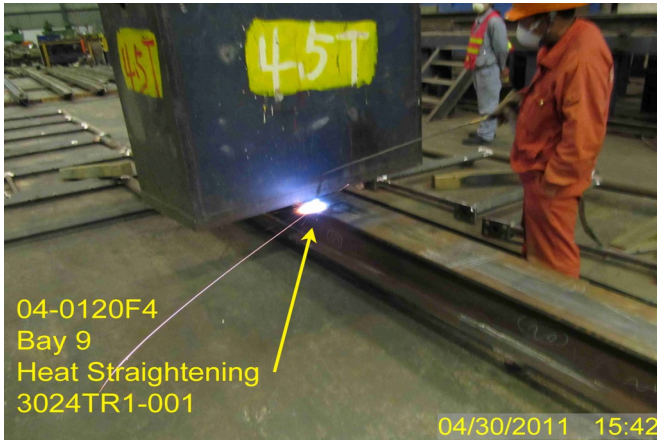
The following digital picture illustrates heat straightening traveler rail assembly 3024TR1-001.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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documents.



Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike
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Quality Assurance Inspector

Reviewed By:	Riley, Ken
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QA Reviewer
